

File: Tuesday, 09/06/2009 12:55:23 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 48438		
Estimate Number	: 13848		
P.O. Number	:	Part Number	: D39071
This Issue	: 09/06/2009 S.O. No. :	Drawing Number	: D3907 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 09/06/2009 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 47973	Material	:
Written By	:	Due Date	: 16/06/2009 Qty: 50 Um: Each
Checked & Approved By	: <u>JUD 09.06.09</u>		
Comment	: Est Rev:A New Issue 09-04-07 JLM Verified By:EC		<u>Rush</u>

Additional Product

Job Number:

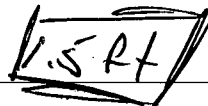


Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0375	304 ROUND BAR 0.375
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* Only 11 inches left.



Comment: Qty.: 0.0368 f(s)/Unit Total: 1.8375 f(s)

304 SS ROUND BAR 3/8"

Batch: M111323

SA 09/06/11

(50)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: 1-TURN AS PER FOLIO FA823 & DWG D3907 ,

FOLIO REV: N/ADWG REV: A

2-DEBURR AS REQUIRED

SA 09/06/11

(50)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/06/11

(50)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

mk 09/06/11

(50)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

PD 09-06-11

(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/06/2009 12:55:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 48438

Part Number: D39071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/12

[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 9/6/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

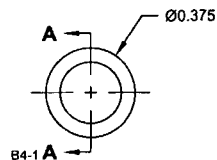
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

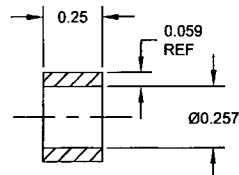
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 108438



D3907-1 BUSHING



SECTION A-A C6-1

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

OR: AISI 304/316 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
09/03/11

A	NEW ISSUE	AJS	09.03.11
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3907	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BUSHING (BASKET REPAIR)	NT
DATE	09.03.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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